

WHAT IS CLAIMED IS:

- 2 *Sub a2* 1. A method of milling a material comprising:
3 providing a silicon nitride based cutting tool insert;
4 cutting at a cutting speed of 1000-3000 m/min; and
5 feeding at a feeding rate of 0.05-0.5 mm/tooth to a cutting depth of
6 0.2-2 mm,
7 wherein the material comprises aluminum and cast iron.
1 2. The method of claim 1, wherein the cutting tool insert has a chip
2 thickness of 0.09-0.17 mm.
- per Spec. p. 12 - 13, not 1 mm all --
is al. w/ cast iron liners*
- an clear
what this means
ex a. ex. 1*
- mm*

add a3